



## PATENT ABSTRACTS OF JAPAN

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(54) **MANUFACTURE OF THERMOPLASTIC RESIN  
 PELLET AND APPARATUS THEREFOR**

(57) Abstract:

**PURPOSE:** To enable pellets to be manufactured stably even in the case of molten strands not sufficient in its tensile strength by continuously extruding heat melted thermoplastic resin from a die, simultaneously, forming strands, and then severing the strands into a predetermined length through highly pressurized water spouted from minute diameter nozzles.

**CONSTITUTION:** In an extruder 16, when thermoplastic resin strands are extruded from a die 12 into a chamber 17, highly pressurized water spouted from nozzle tips fixed on a rotating hollow shaft 11 strikes at right angles with respect to the advancing direction of the thermoplastic resin strands, and thus the strands are severed into pellets of the order of 1-5mm in its length. Since the highly pressurized water is spouted continuously, when not required to sever the strands, it hits the wall surface of the chamber 17 directly and therefore comes to mist within the chamber 17, and

the severed pellets are cooled immediately and then transported out along with water from a transporting hole 18. In this way, even in the case of thermoplastic resin having no large tensile strength of strands, it can be severed easily.

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